

# Work Order ID 73424

Wednesday, August 31, 2011 3:17:11 PM



Page 1

Item ID: D3535-25	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Wearshoe					
Start Date: 8/31/2011	Start Qty: 10.00		Cust Item ID:		
Required Date: 9/16/2011	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/09/01</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
304 . 04C	1-Cut as per Dwg D3535 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2- Deburr if necessary								

11-9-19

(13)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

11-9-19

120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

8/10/19

Y13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73424**

Wednesday, August 31, 2011 3:17:11 PM

Page 2

Item ID: D3535-25

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 8/31/2011 Start Qty: 10.00

Required Date: 9/16/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Brake NC

NC BRAKE

0.00

Memo

0.00

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326  
2-Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25

Brake NC

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Powder Coating

W117338

32005

12:30

13x Ø M-L 11/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 73424

Wednesday, August 31, 2011 3:17:11 PM



Page 3

Item ID: D3535-25

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 8/31/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

13 ~~0~~ M 11/09/20  
COUNTED a meso20 OK!

170

Identify as per dwg & Stock Location: FPI

0.00



Packaging

Memo

0.00

Packaging

13X ~~0~~ M 11/09/20

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/21 ~~0~~  
MF 11-09-21

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 31, 2011 3:17:09 PM

Page 1

Work Order ID: 73424



Parent Item: D3535-25



Parent Item Name: Wearshoe



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	212.4072	0.51	5.368421	6.7		
												B1-9-19	

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

212.4072

116623

0.2

117550

9.363

117933

79.3442

118400

123.5

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
118400

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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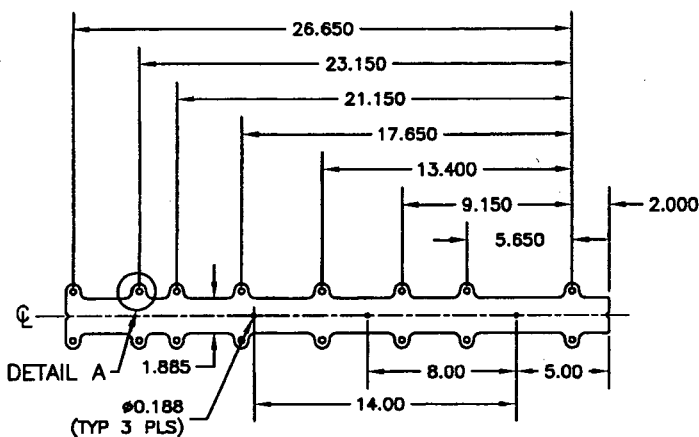


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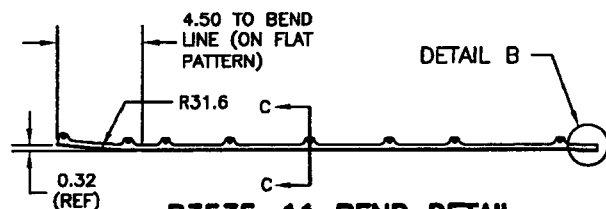
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07.04.24

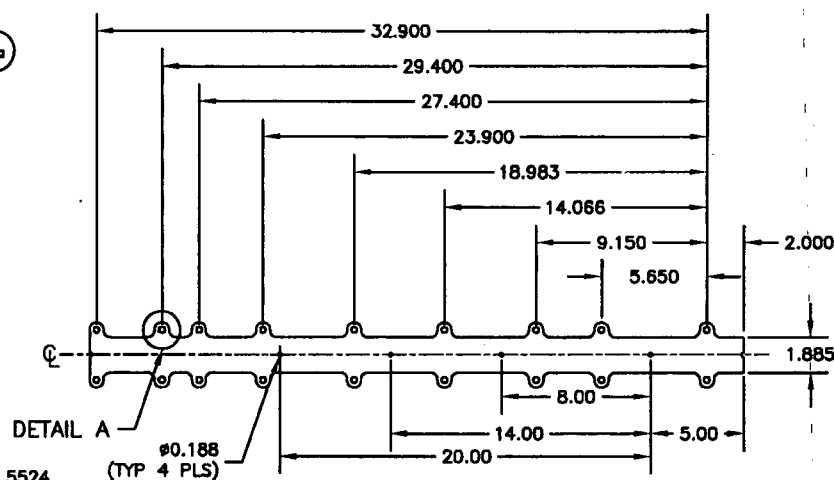
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73424



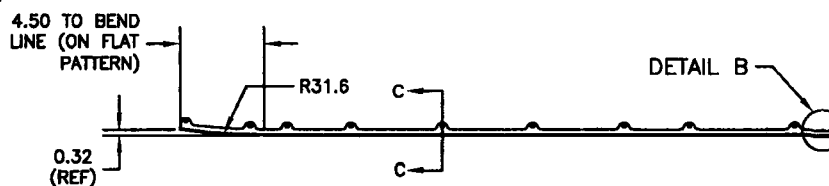
**D3535-11F FLAT PATTERN**



**D3535-11 BEND DETAIL**



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

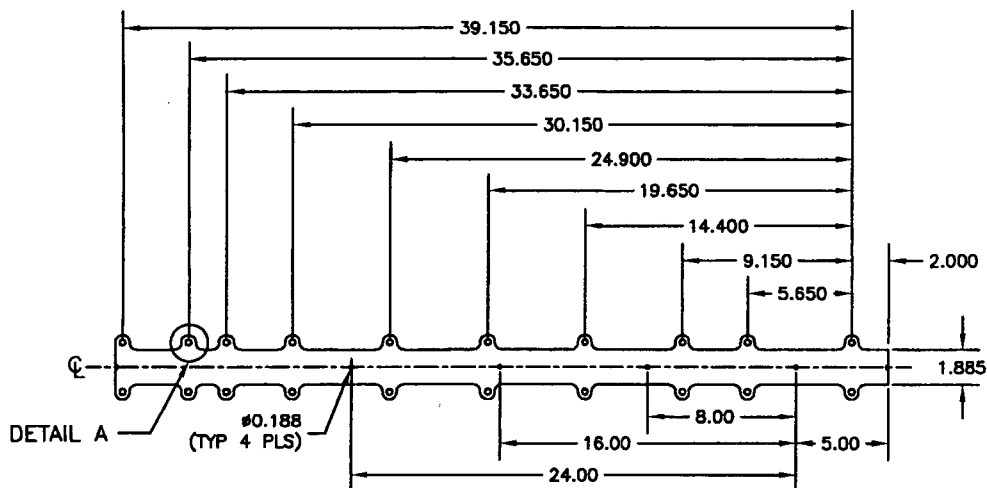
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		D3535
DATE	TITLE	SHEET 1 OF 7
07.04.17	WEARSHOE	SCALE
		1:10
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

**DART**

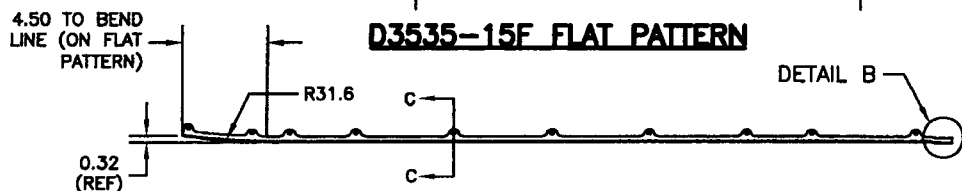
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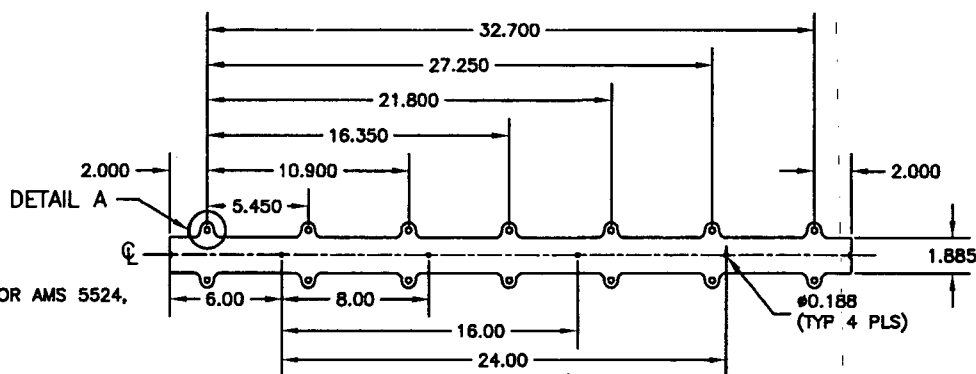
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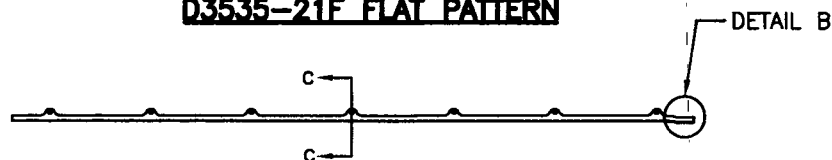
**D3535-15F FLAT PATTERN**



**D3535-15 BEND DETAIL**



**D3535-21F FLAT PATTERN**



**D3535-21 BEND DETAIL**

**NOTES**

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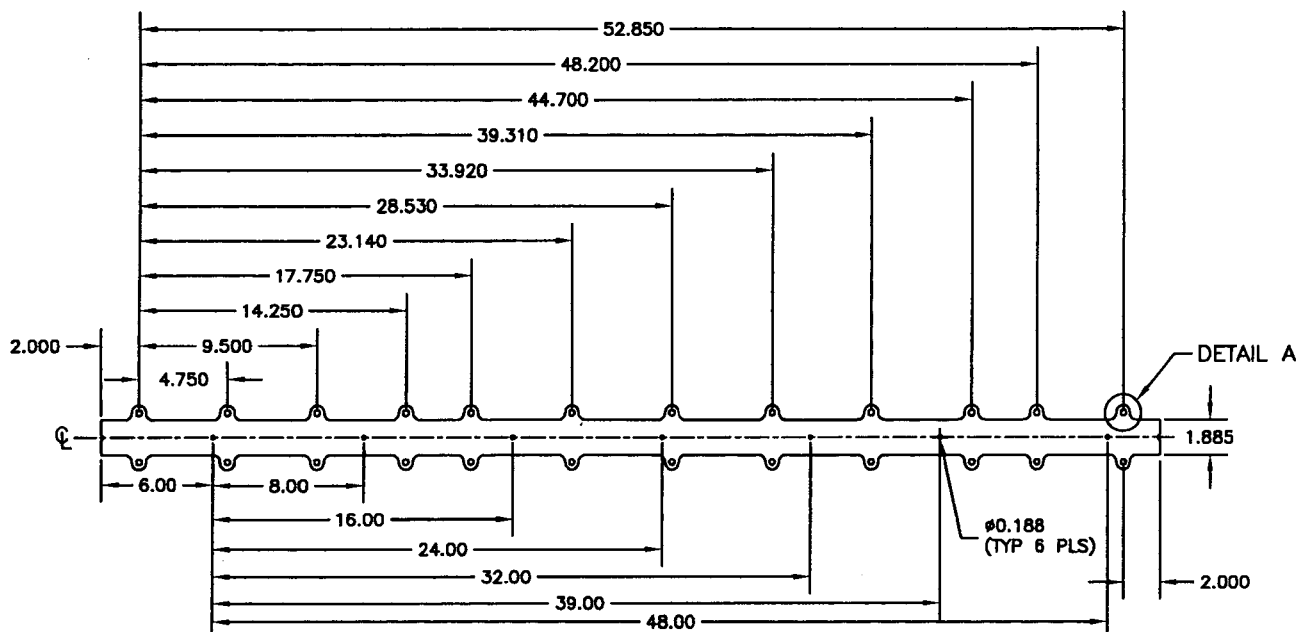
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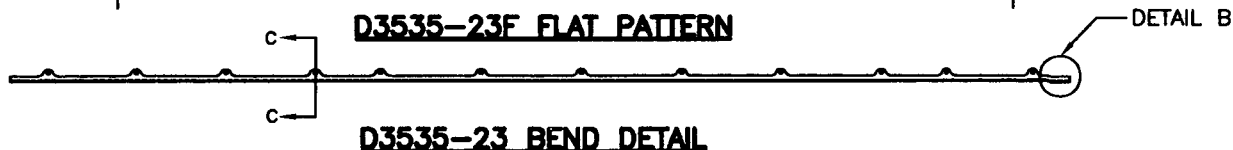
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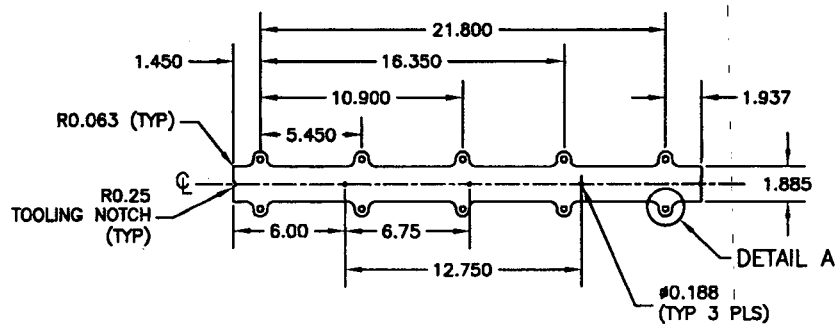
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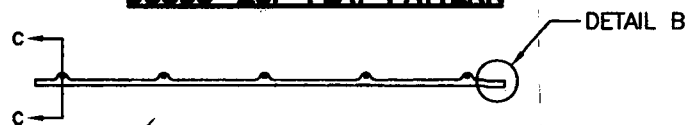
**D3535-23F FLAT PATTERN**



**D3535-23 BEND DETAIL**



**D3535-25F FLAT PATTERN**



**D3535-25 BEND DETAIL**

**NOTES**

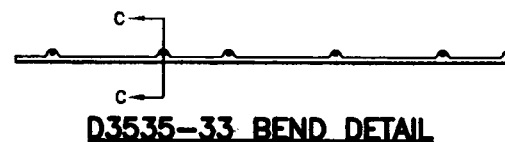
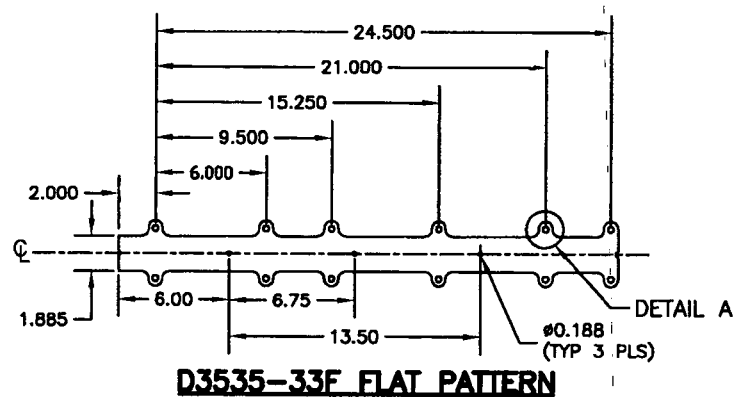
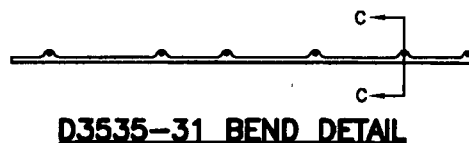
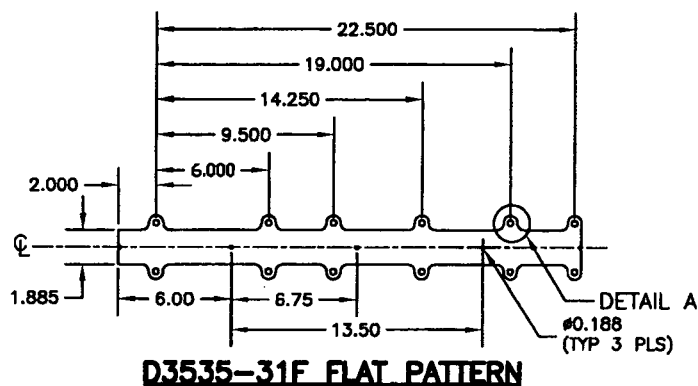
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 3 OF 7
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**NOTES**

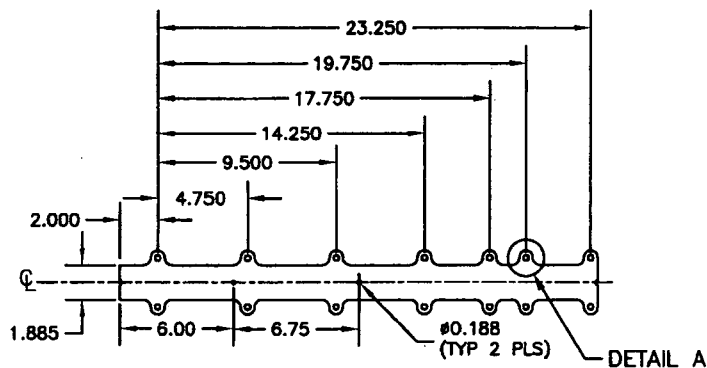
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DATE	TITLE	SCALE	
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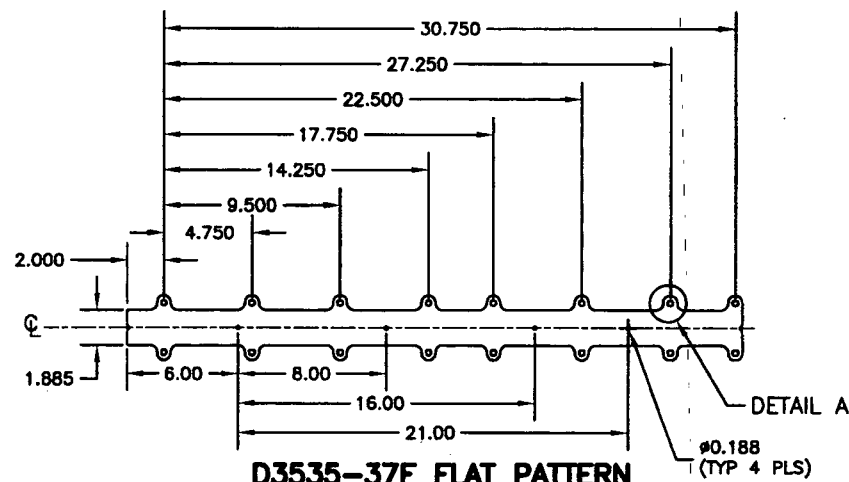
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DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 5 OF 7
	SCALE <b>1:10</b>	



**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

**NOTES**

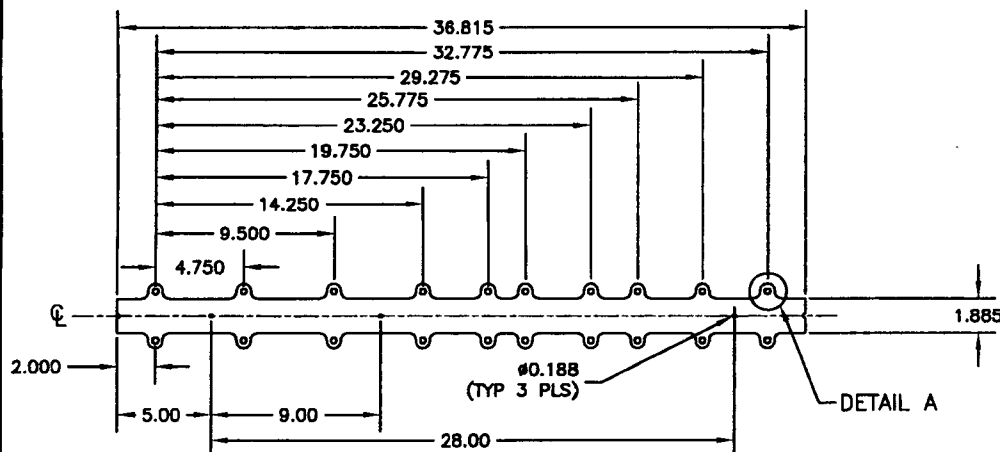
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**DART**

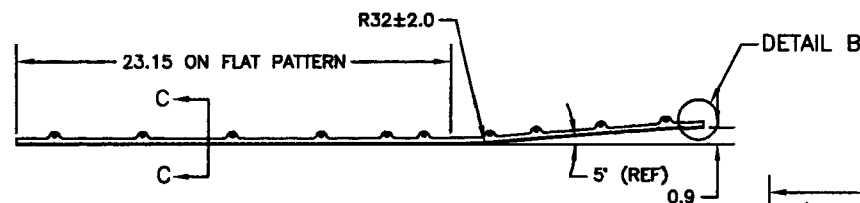
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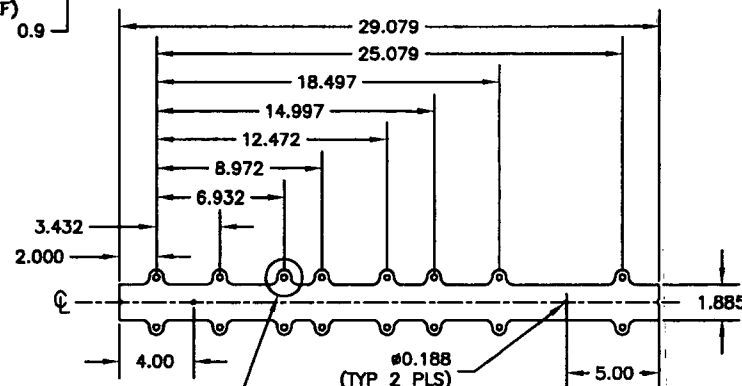
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DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 6 OF 7
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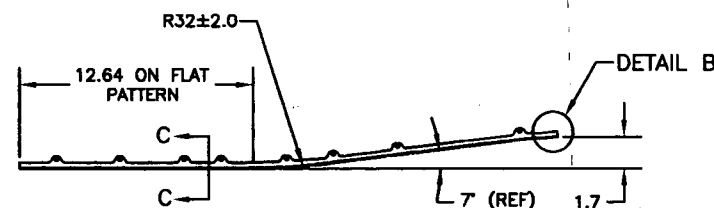
**D3535-39F FLAT PATTERN**



**D3535-39 BEND DETAIL**



**D3535-41F FLAT PATTERN**



**D3535-41 BEND DETAIL**

**NOTES**

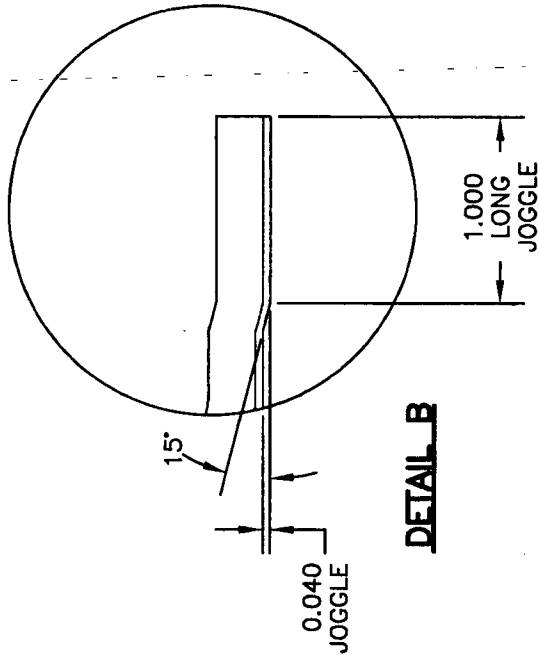
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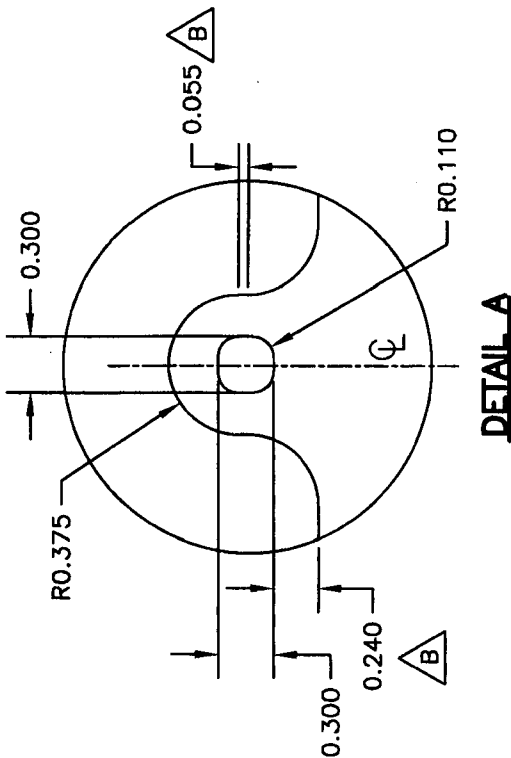
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DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

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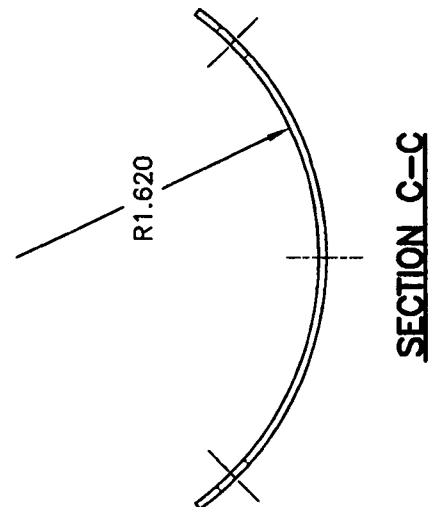
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**DETAIL B**



**DETAIL A**



**SECTION C-C**

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